

Date: Tuesday, 4/18/2006 10:06:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 26684		
Estimate Number	: 11554		
P.O. Number	: N/A	Part Number	: D30771
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3077 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A2
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/10/2006
Checked & Approved By	: <u>06.04.18</u>	Qty:	<u>20</u> Um: Each
Comment	: Est B 02.11.18 Incorporated D3170-1 IPP KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.6125 sf(s)/Unit Total : 36.7479 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)
 Batch: M100742

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 12.100" x 6.070" (+0.030/-0.000)

New machine water jet. N/A

3.0	HAAS <i>water jet</i>	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Cut as per
 Machine per Folio FA284 and Dwg D3077

Req: Rev A
Dwg: Rev A *06/04/28* *(20)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/04/28 *(20)*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06.05.04 *20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr to take measurement

SAD

06/05/04

20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06/05/04

20

8.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/CHEMICAL CONVERSION

06/05/04

20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

06/05/04

20

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/04

Job Completion



W 06/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

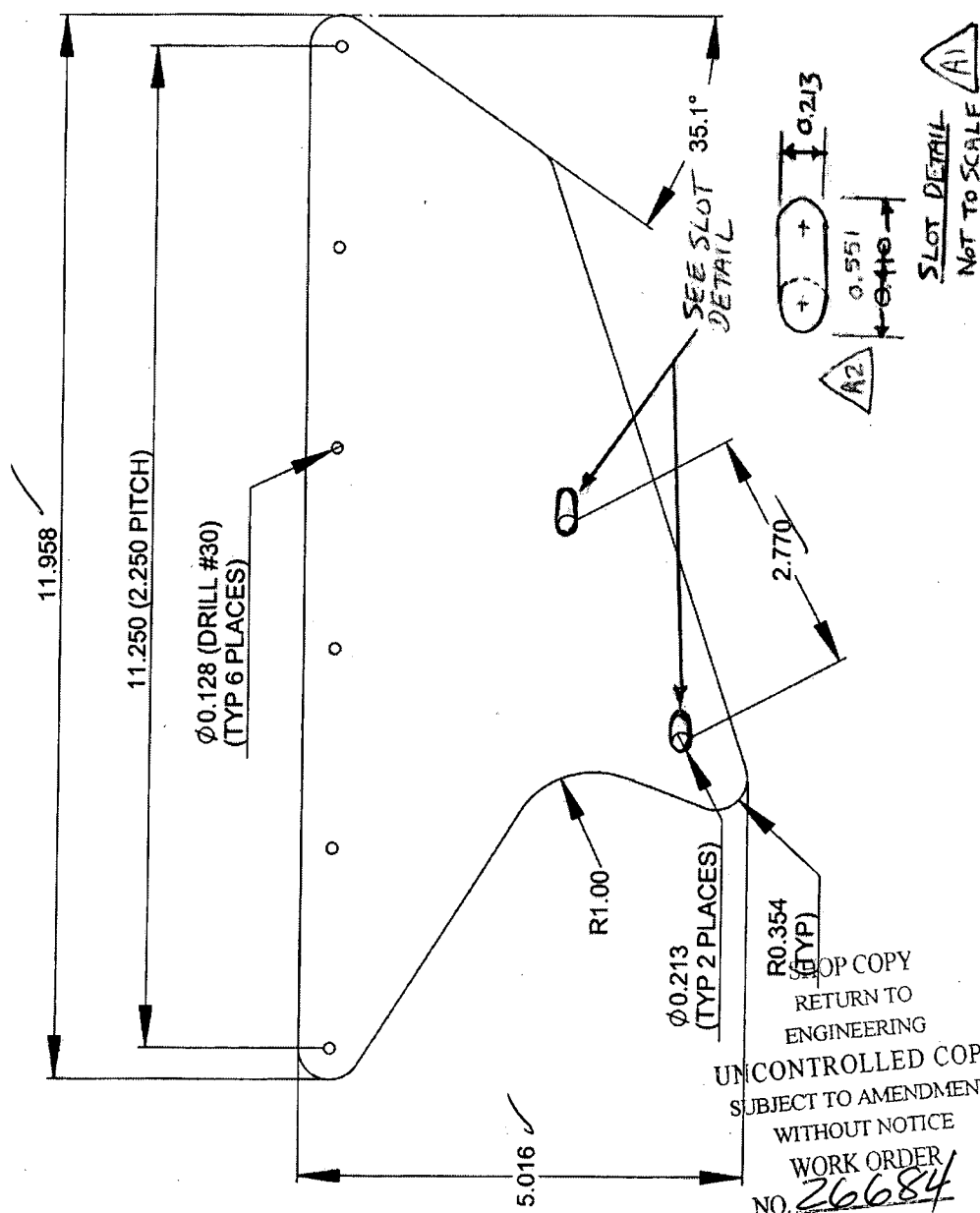
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.09.2014

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3077	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE STEP LEG	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 CP H	ADD SLOTS	
A2	03.02.27 CP H	0.551 WAS 0.410	



D3077-1 STEP LEG

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRT"
2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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